

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018840**Date Inspected:** 12-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang Jie**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance(QA) Inspector Mr.Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. The QA Inspector observed and/or found the following:

BAY # 14

**MAGNETIC PARTICLE TESTING**

ZPMC NWIT: 07320

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% of the length previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an (MT) report on this date. The members are identified as SEG3019AQ. The weld designations are as follows:

SEG3019AQ-026~028

**MAGNETIC PARTICLE TESTING**

ZPMC NWIT: 07328

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% of the length previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an (MT) report on this

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

date. The members are identified as SEG3019AQ. The weld designations are as follows:

SEG3020AQ-026~029

This QA Inspector randomly observed the following work in progress.

BAY # 14

OBG13 EAST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 054013 performing the Shielded Metal Arc Welding process on weld 125 located at PCMK SEG3007B. ZPMC QC Mr. Zhong Yong Gang was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-Tc-u4b-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044772 performing the Shielded Metal Arc Welding process on weld 170 located at PCMK SEG3007C. ZPMC QC Mr. Zhong Yong Gang was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-Tc-u4b-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 049861 performing the Shielded Metal Arc Welding process on weld 221 located at PCMK SEG3007B. ZPMC QC Mr. Zhong Yong Gang was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2114-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 200113 performing the Shielded Metal Arc Welding process on weld 228 located at PCMK SEG3007B. ZPMC QC Mr. Zhong Yong Gang was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2114-Fcm-1.

OBG 14 WEST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 201215 performing the Flux Cored Arc Welding process on weld 106 located at PCMK SEG3020AB. ABF QA Mr. Shen was monitoring this welding operation. The welding variables recorded by QA appeared to comply with WPS-B-T-2232-Tc-u5-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045175 performing the Flux Cored Arc Welding process on weld 107 located at PCMK SEG3020AB. ABF QA Mr. Shen was monitoring this welding operation. The welding variables recorded by QA appeared to comply with WPS-B-T-2232-Tc-u5-f.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---



## Summary of Conversations:

No significant conversations were reported on this date.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

---

**Inspected By:** Utekar,Shrikant

Quality Assurance Inspector

---

**Reviewed By:** Patterson,Rodney

QA Reviewer